

**Work Order ID 58220**

April 29, 2010 11:38:29 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 29/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-4-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	Rev D								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041								
	CHG002								
110		0.00							
	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT009								
	2-Cut tubes as per Dwg. D2580								

N/A

4/15/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

U10/5/19

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BE 10/05/19

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Page 3

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QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004.

A/R Aluminum Rod

*ML12860*

*BE 10/25/19*

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

*ML12860*

*BE 10/05/19*

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

*4 10/15/20*

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Page 4

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
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DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S 10/5/10

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/5/10

⑩

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

① BR 10-5-25.

W/O:		WORK ORDER CHANGES					
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Page 5

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NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

12114207

0.00

0.00

= 7 JEL 10/05/25

1 0

Memo

START TIME:

1:00 PM

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:30 PM

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

10 00 01 (1)

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April 29, 2010 11:38:29 AM



Page 6

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
	HandFinish					ml	10	06	01 ⑥
Hand Finishing	Memo	0.00							
	1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 113435 <input type="checkbox"/> <input type="checkbox"/> Sikaflex expire date: 10/11								
	2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580								
	3-Inspect for foreign object per QSI 024								
	4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 113435 <input type="checkbox"/> <input type="checkbox"/> Sikaflex expire date: 10/11								
	5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 114432								

ml 10 06 01 ①

① 10 06-2

W/O:		WORK ORDER CHANGES					
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Page 7

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10106102

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024



220



Packaging

Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: PPP 5849310/06/04 (1)

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/04 JF  
ME  
10-6-03

W/O:		WORK ORDER CHANGES					
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April 29, 2010 11:38:34 AM

Page 1

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 29/04/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 8.0000 1



205 Skidtube bent detail



B58618 u 0/5/18

Location	Loc Qty	Loc Code
LG	8	
57028	1	
57188	1	
57347	2	
57902	2	
57938	2	

D2576-3 Manufactured No 140 Each 114.0000 1



Step (maching detail)



Location	Loc Qty	Loc Code
LG	114	
46661	66	
52215	48	

1 BE 10/05/19

D2579 Manufactured No 140 Each 273.0000 20



Crossbolt Spacer



Location	Loc Qty	Loc Code
LG	273	
57052	13	
57348	260	

20 BE 10/05/19

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 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 29/04/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 112.0000 1



Cap

Location	Loc Qty	Loc Code
FP6	2	
56613	2	
ST026	110	
50513	1	
50770	29	
51539	26	
53791	54	

1 Bk 10-6-2

AN3-5A Purchased No 200 Each 991.0000 2



Bolt

Location	Loc Qty	Loc Code
ST350	991	
105057	991	

2 Bk 10-6-2

AN960JD10L Purchased No 200 Each 4,379.000 2



Washer

Location	Loc Qty	Loc Code
ST348	4379	
110985	4379	

2 Bk 10-6-2

ALS7-1032-130 Purchased No 200 Each 30.0000 50



Insert

Location	Loc Qty	Loc Code
ST282	30	
114654	30	

50 Bk 10-6-2

ALS4-1032-130 114654

April 29, 2010 11:38:34 AM

Shop Packet Print

Page 2

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April 29, 2010 11:38:34 AM

Page 3

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 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 29/04/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 2,355.000 50



BOLT

Location	Loc Qty	Loc Code
ST350	2355	
114103	501	
114108	300	
114330	54	
114416	500	
114523 ✓	1000	

AN960C10L Purchased No 200 Each 0.0000 50



washer

D3566-13



Gasket

NAS 1149C0332R

11434

50 Bk 10-6-2

50 Bk 10-6-2

Manufactured No 200 Each 41.0000 1

Location	Loc Qty	Loc Code
FP	41	
53461 ✓	41	

D3566-5 Manufactured No 200 Each 31.0000 1



Gasket

Location	Loc Qty	Loc Code
FP015	31	
56829	1	
57526	10	
57682 ✓	20	

1 Bk 10-6-2

1 Bk 10-6-2

April 29, 2010 11:38:34 AM

Shop Packet Print

Page 3

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IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 58.0000 2



Gasket



Location	Loc Qty	Loc Code
FP015	58	
57257	1	
57715	36	
58182 ✓	21	

D3564-11 Manufactured No 200 Each 4.0000 1



Wearshoe



Location	Loc Qty	Loc Code
FP19	4	
57259	4	

D3564-13 Manufactured No 200 Each 22.0000 1



Wearshoe



Location	Loc Qty	Loc Code
FP17	22	
56533	10	
57684 ✓	12	

2 BL 10-6-2

1 BL 10-6-2

1 BL 10-6-2

April 29, 2010 11:38:34 AM

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Page 4

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-9 Manufactured No 200 Each 15.0000 1



Wearshoe



Location	Loc Qty	Loc Code
FP 57958	1	
55334	1	
FP019	14	
57260	3	
57685	11	

1 BR 10-6-2

D3564-5 Manufactured No 200 Each 7.0000 1



Wearshoe



Location	Loc Qty	Loc Code
FG 58709	2	
34806	2	
FP19	5	
57525	5	

1 BR 10-6-2

D2594-3 Manufactured No 200 Each 99.0000 16



O-Ring, 205 Skidtube



Location	Loc Qty	Loc Code
FP 58141	99	
55546	99	

16 BR 10-6-2

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Page 6

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Start Date: 29/04/2010

Required Date: 13/05/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1 Manufactured No 200 Each 526.0000 16



Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP	526	
42807	112	
55002	208	
57826 ✓	206	

Re. 10-6-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58219

*8/10-4-29*

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

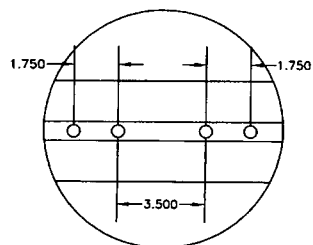
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

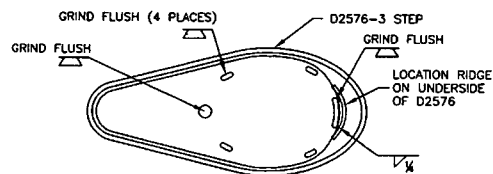
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DETAIL A**  
SCALE 5:24

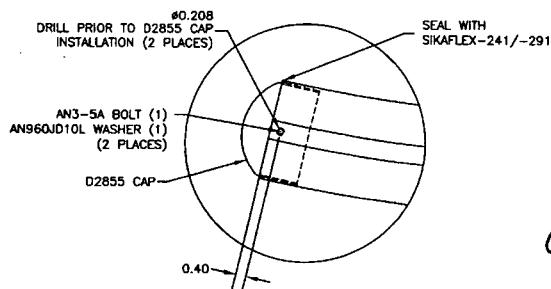


**DETAIL B**  
SCALE 5:24

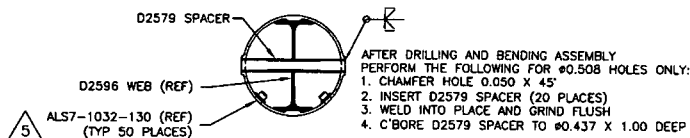


**RELEASED**  
07 Dec 88

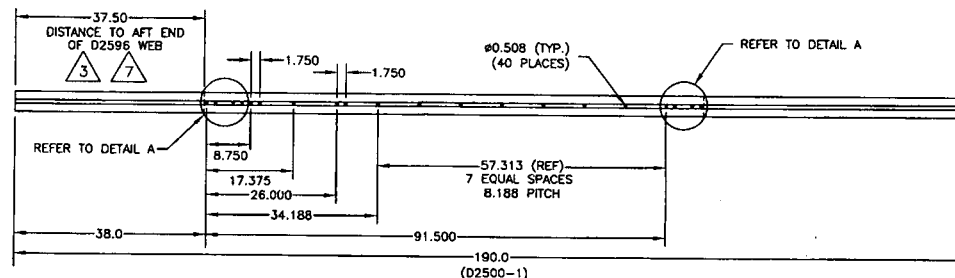
**DETAIL C**  
SCALE 5:24



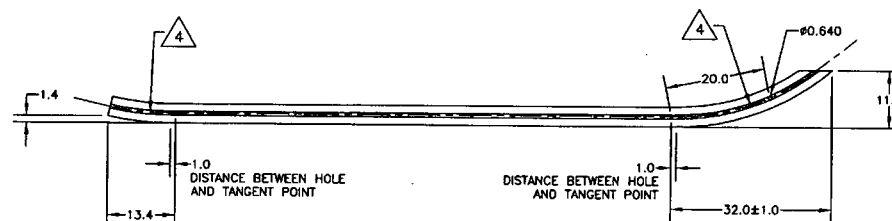
**SECTION D-D**  
SCALE 5:24



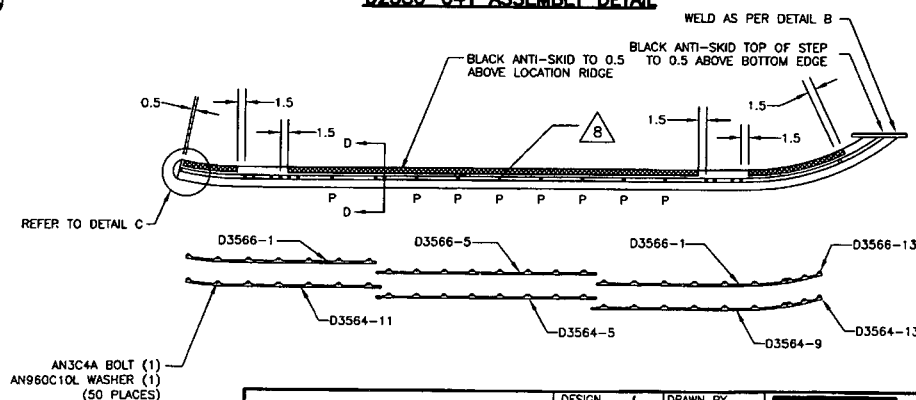
**D2580-1 DRILLING DETAIL**



**D2580-1 BENDING AND CUTTING DETAIL**



**D2580-041 ASSEMBLY DETAIL**



**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

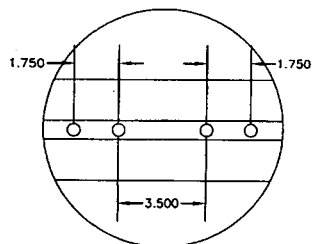
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

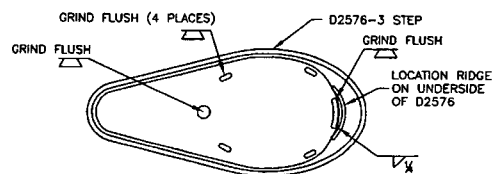
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DETAIL E**  
SCALE 5:24

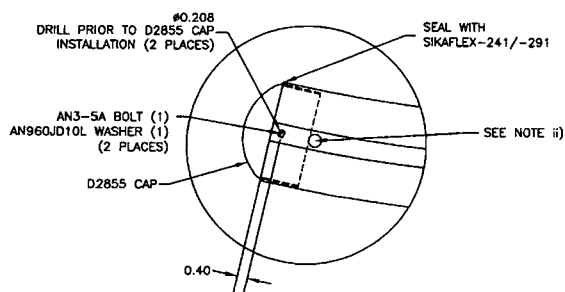


**DETAIL F**  
SCALE 5:24

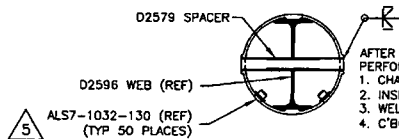


**RELEASED**  
07 Dec 88

**DETAIL G**  
SCALE 5:24

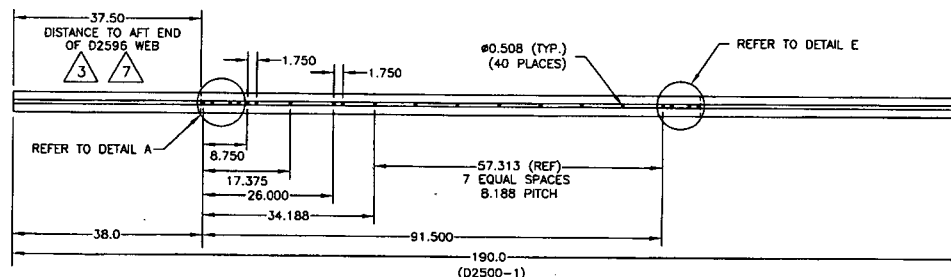


**SECTION H-H**  
SCALE 5:24

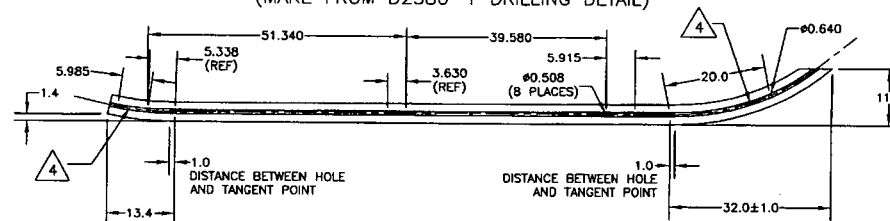


- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2579 SPACER (20 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

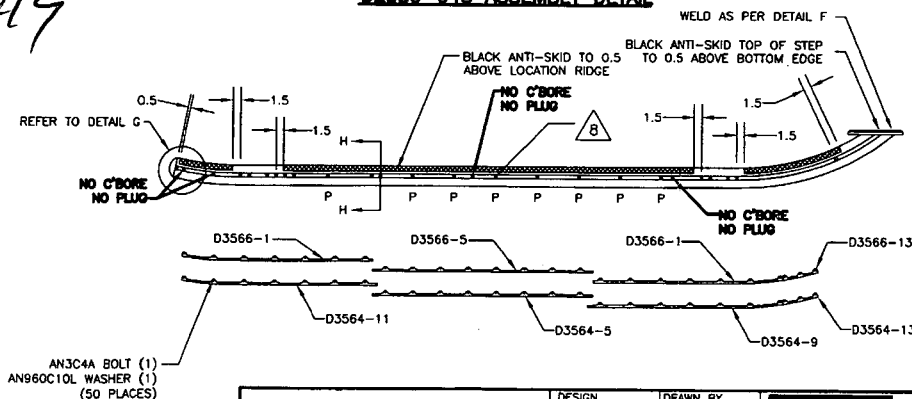
**D2580-1 DRILLING DETAIL**



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



**D2580-045 NOTES**

- FINISH:** ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 3 SCALE 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NO. 232

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 58008  
Part number: D205 634 041  
Description: 205 tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Donohue Date of Test Coupon 10.05.18  
Welder Barclay Elliott Date of Test Coupon 10.05.18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld